

Thursday, 27/11/2008 2:25:44 PM

B Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET LID ASSEMBLY		
Job Number	: 43819B		Part Number	: D2989043		
Estimate Number	: 10207		Drawing Number	: D2989 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 27/11/2008	S.O. No. :	Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : LARGE FAB ASSY	Due Date	: 20/12/2008	Qty:	1 Um: Each
Previous Run	: 43790					
Written By	:					
Checked & Approved By	: JLM 08-11-27					
Comment	: Est Rev:I Removed D2989-041 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31821	Hinge	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Pick:		
	✓ Qty Part number	Description Batch	
	2 D3182-1	Hinge B43293	 
2.0	D34423	Shim	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Pick:		
	✓ Qty Part number	Description Batch	
	2 D3442-3	Shim B42718	 
3.0	M304EX07516F	Expanded Metal Flat SS	
	Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)		
	Pick:		
	✓ Qty Part number	Description Batch	
	8sf M304EX0.75-16F Expanded Metal	M109384	 
4.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
	Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)		
	3/4" x 3/4" x 0.065" wall 304/316 SStubing.		
	Batch: M109731		 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:25:44 PM  
User: Julie Dawson

## Process Sheet

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 43819B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note:D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

SAP 08/12/11 (D)

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

SL 08/12/11 (X)

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/12/11

7.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/12/11 (X)

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

(X)

1- Plug holes in D2989-17 and D2989-2 prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

2 = 30  
0F

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

3 = 15  
0F

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M-A 08/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:25:44 PM  
User: Julie Dawson

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 43819B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION

Ex 08/12/23 ①

Comment: Inspect Powder Coat

10.0 QC21



FINAL INSPECTION/W/O RELEASE



08/12/24 ②

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/12/23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries

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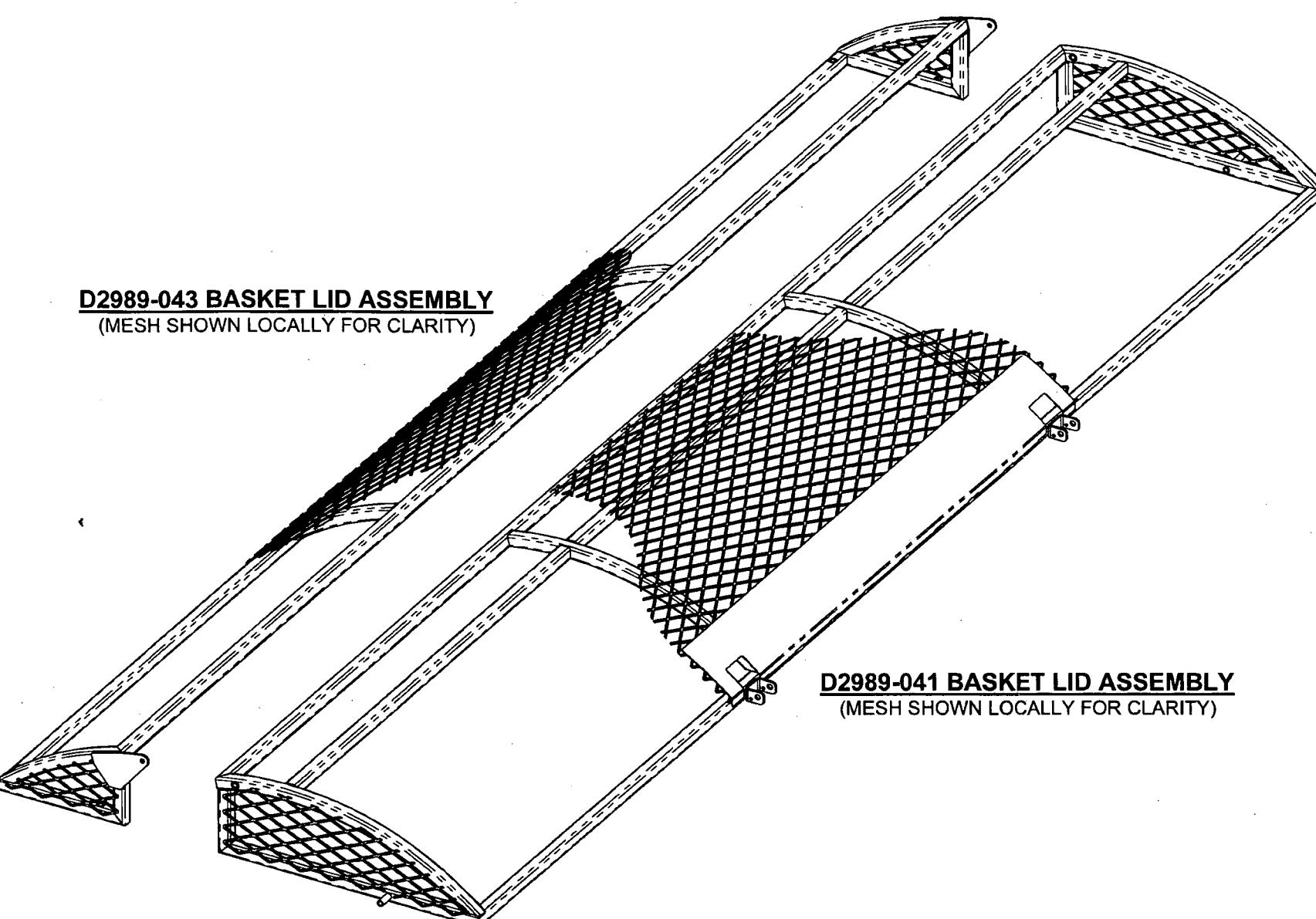
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

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WITHOUT NOTICE

WORK ORDER

RELEASED  
08/11/18 MB 1043819B

D	REVISED -041-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9-15; D3836-042 REPLACES D2989-10-15; D3838-041 REPLACES D2989-1-7; D3838-042 REPLACES D2989-2-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9-10 (NOW ON D3838 DWG), D2989-11-2-7-15 (NOW ON D3838 DWG) AND D2989-11-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27

REV.	DESCRIPTION		BY	DATE
DESIGN	DS			
DRAWN				
CHECKED	AS			
MFG. APPR.				
APPROVED	DP			
DE APPR.				
DATE	08.09.24			

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

REV. D  
SHEET 1 OF 5

TITLE  
**BASKET LID ASSEMBLY**  
SCALE  
NTS

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**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

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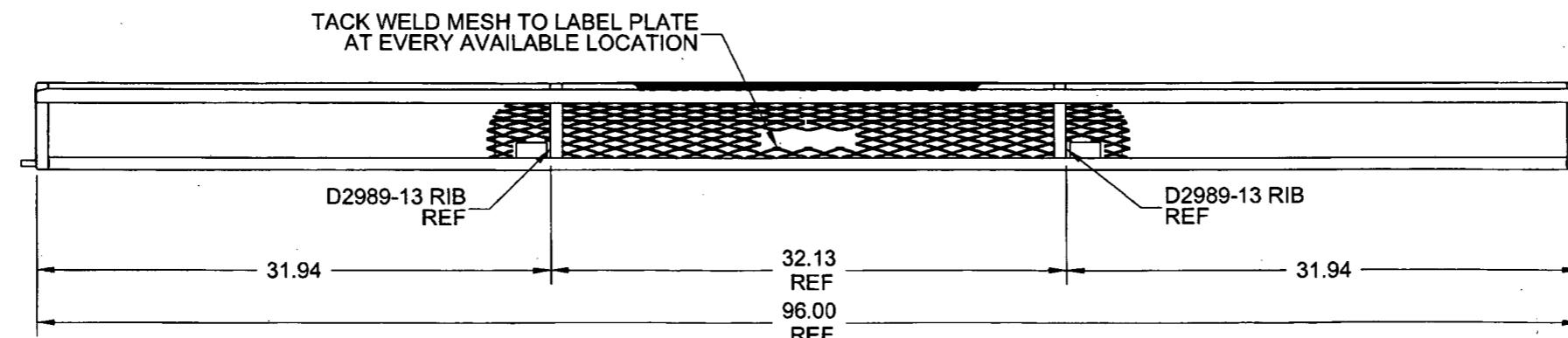
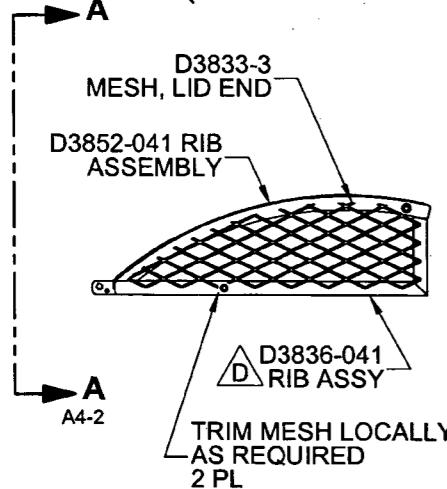
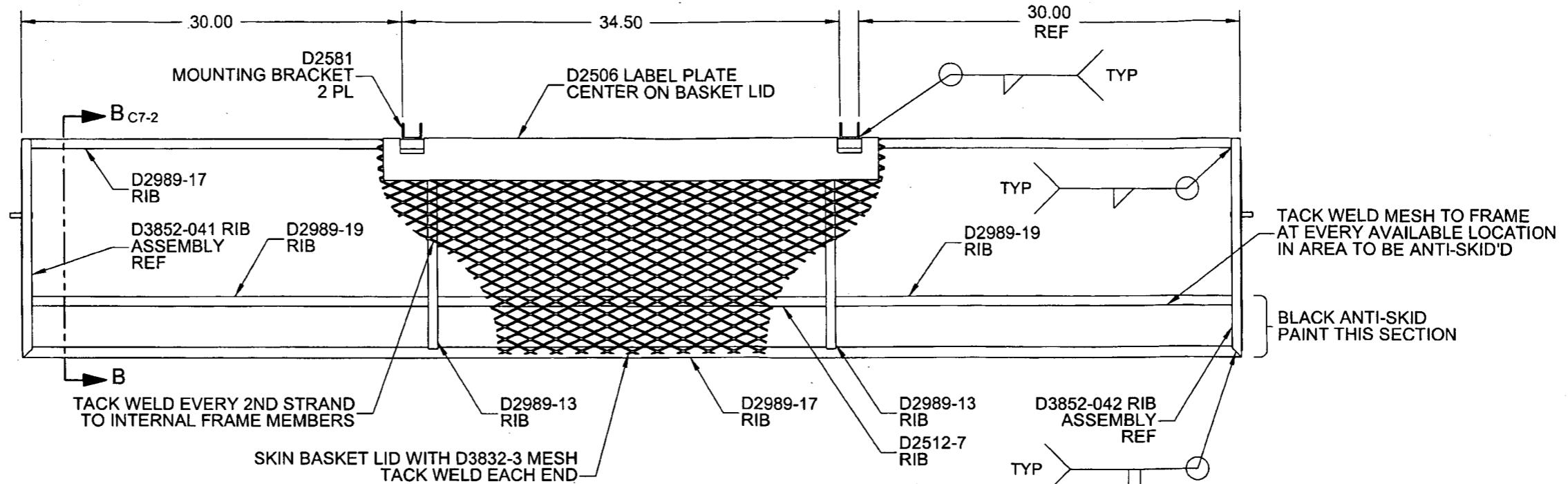
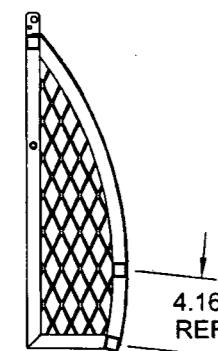
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8 7 6 5 4 3 2 1



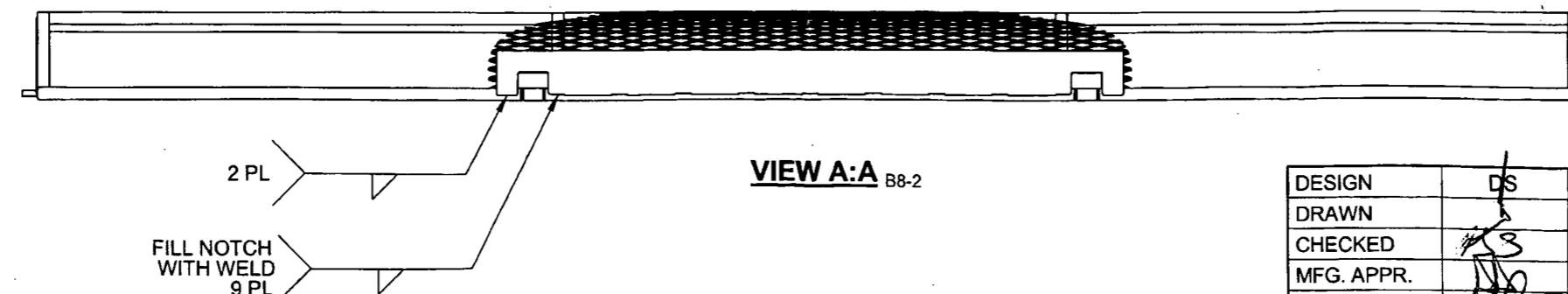
D3833-3 MESH, LID END

D3852-042 RIB ASSEMBLY

D3836-042 RIB ASSY

TRIM MESH LOCALLY AS REQUIRED 2 PL

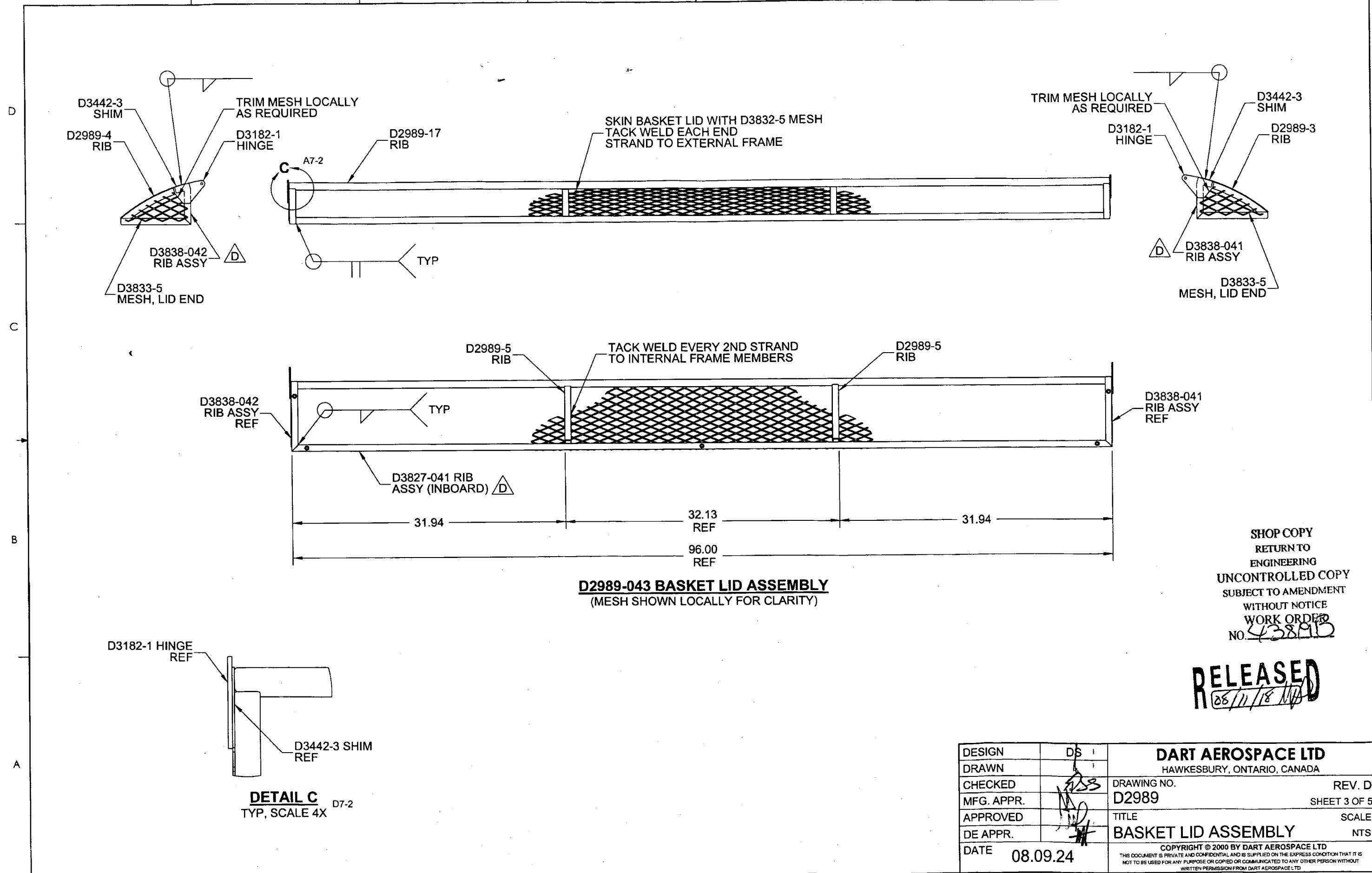
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		SHEET 2 OF 5
		SCALE
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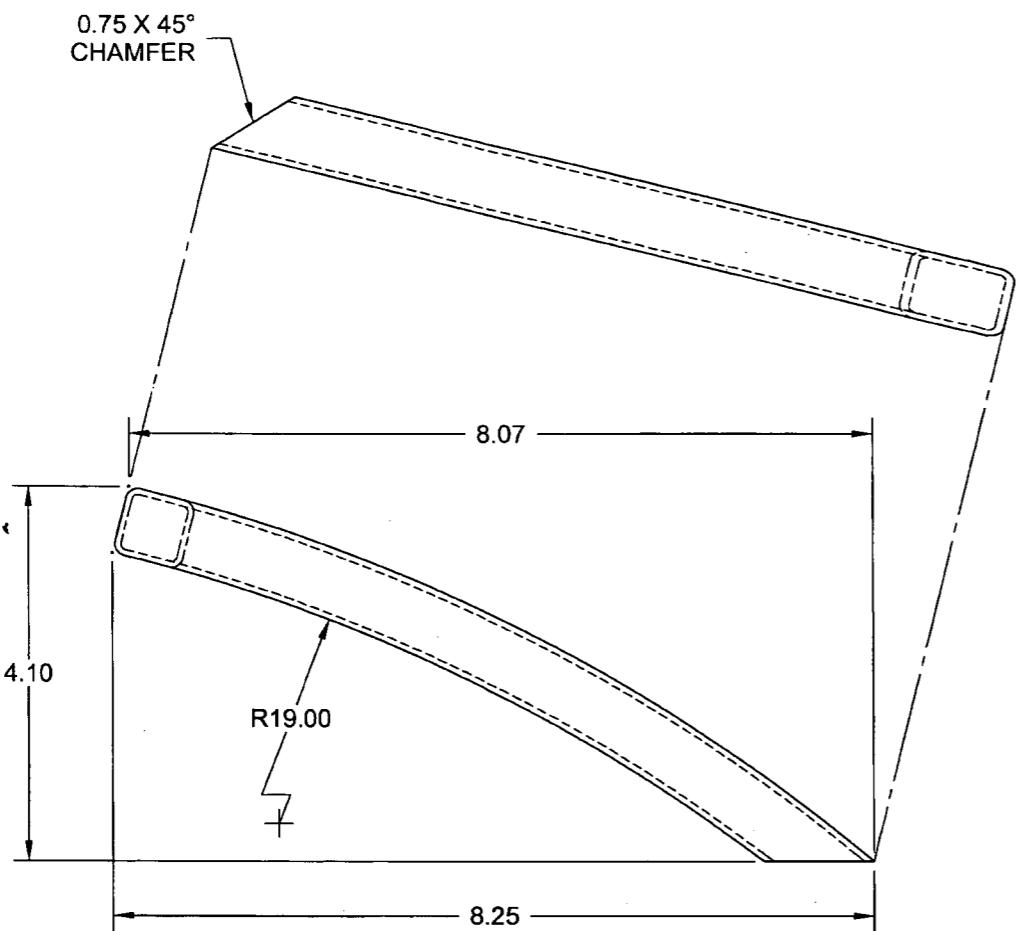
8 7 6 5 4 3 2 1



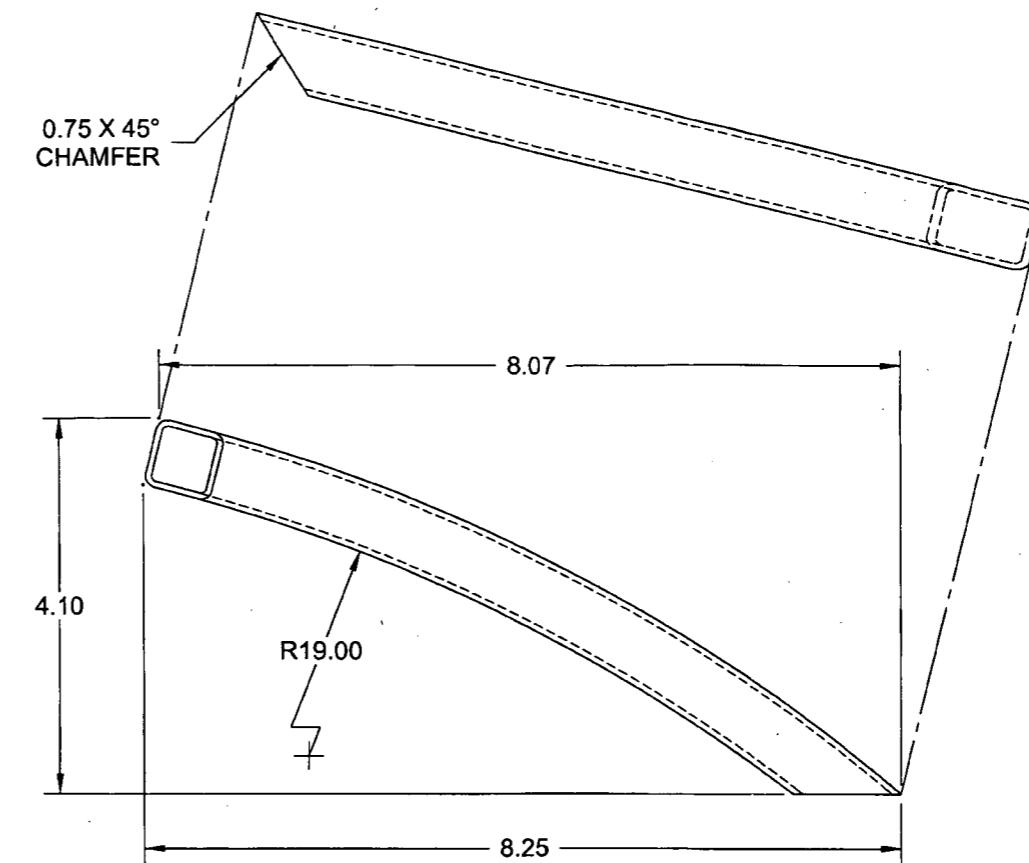
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D2989-3 RIB



D2989-4 RIB

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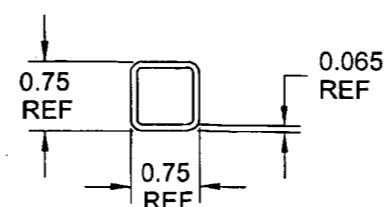
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NOTES:  
1) MATERIAL: D3166-3 BASKET HOOP  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
8) WEIGHT: D2989-3/-4 = 0.39 lbs;



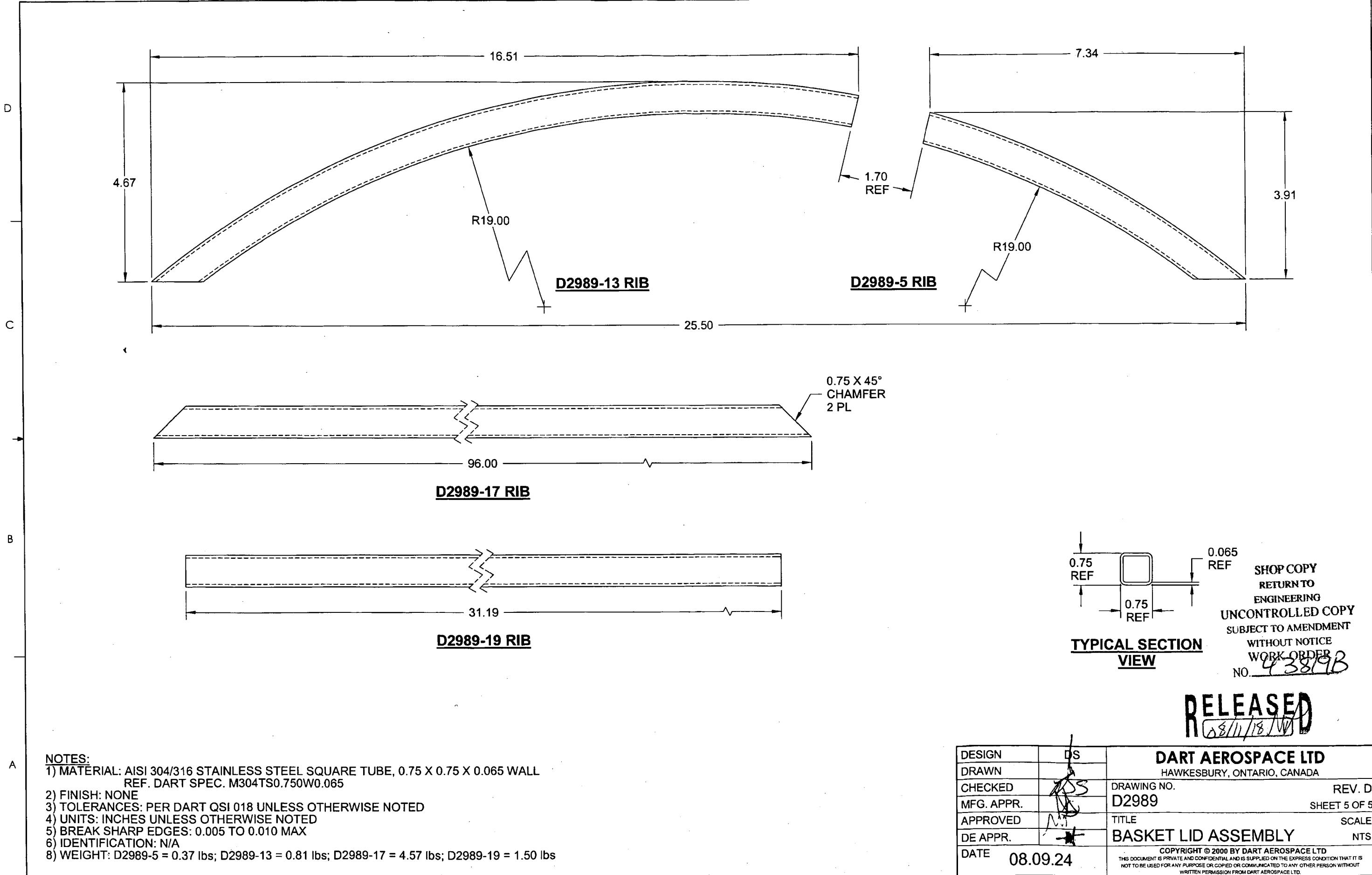
TYPICAL SECTION  
VIEW

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APPROVED	<i>MJ</i>	D2989
DE APPR.	<i>MJ</i>	SHEET 4 OF 5
DATE	08.09.24	TITLE
		SCALE
		BASKET LID ASSEMBLY
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